

Work Order ID 123889

Thursday, August 28, 2014 1:27:19 PM

123889

Ship set up *4th* Page 1

Item ID: EA20469-24 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rod
 Start Date: 8/28/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/28/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 14-8-28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
EA2046901	1

100	DOOSAN LATHE	0.00				1	0		<i>SA</i> 14-9-2
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100
 Doosan
 Doosan Lathe

Memo
 1- Turn as per Folio FA
 Rev: WJA
 Rev: (
 3-Deburr per dwg

110	QC2- Inspect parts off machine FAI/FAIB	0.00				1	0		<i>SA</i> 14-9-2
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110
 QC
 Quality Control

Memo
 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Equip/Tooling									
Handling/Pre									
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Operator									
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Process									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

Thursday, August 28, 2014 1:27:17 PM

Page 1

Work Order ID: 123889

123889

Parent Item: EA20469-24

FA20469-24

Parent Item Name: Rod

Start Date: 8/28/2014

Required Date: 8/28/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-02-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NR0.750

Purchased

No

100

f

24.1700

0.166

1

M4130NR0 750

4130 steel RD bar .750"

**

14-9-2

SA

Location

Loc Qty

Loc Code

MAT031

24.17

111823

2

123772

9.15

1127753

13.02

4130.375.090 Wall

M108059

1 Pt

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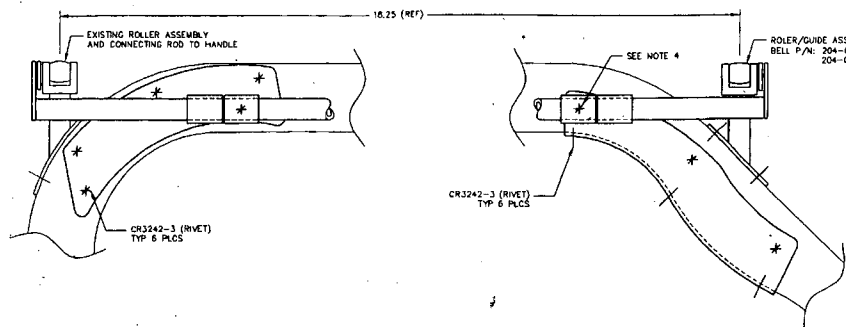
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence- ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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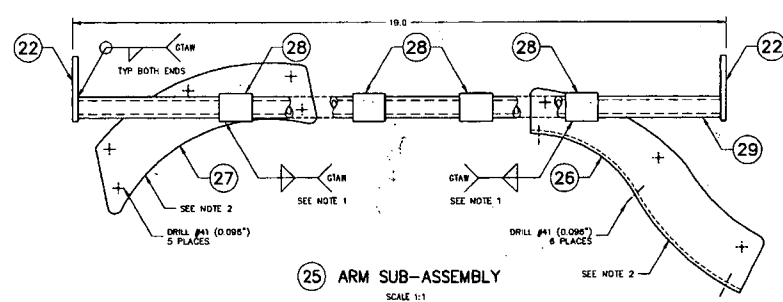
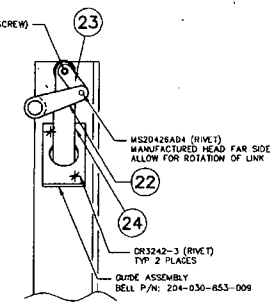
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205

#123889

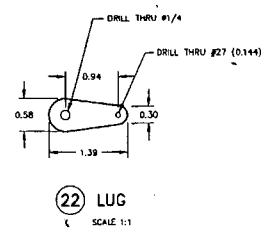
NOTICE			
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	OW	15 AUG 2000



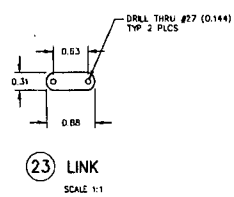
UPPER DOOR LATCH ASSEMBLY
SCALE 1:1



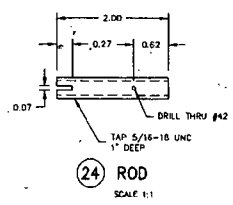
ARM SUB-ASSEMBLY
SCALE 1:1



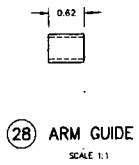
22 LUG
SCALE 1:1



23 LINK
SCALE 1:1



24 ROD
SCALE 1:1



28 ARM GUIDE
SCALE 1:1

- NOTES FOR SHEET 3.
- WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 6457A OR LATER REVISION.
 - HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PLOTT HOLE LOCATIONS ARE APPROPRIATE. MAINTAIN 30 EDGE DISTANCE.
 - THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
 - OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

QTY.	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	29	ARM	EA20469-29	4130 STEEL	MIL-T-8738	63/8 O.D. x 0.063 WALL
4	28	ARM GUIDE	EA20469-28	4130 STEEL	MIL-T-8738	61/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	EA20469-27	MILD STEEL		0.063" SHEET
1	26	DOOR PLATE	EA20469-26	MILD STEEL		0.063" SHEET
1	25	ARM SUB-ASSEMBLY	EA20469-25			
1	24	ROD	EA20469-24	4130 STEEL	MIL-T-8738	63/8 O.D. x 0.063 WALL
2	23	LINK	EA20469-23	4130 STEEL	MIL-S-10729	0.063" SHEET
2	22	LUG	EA20469-22	4130 STEEL	MIL-S-10729	0.063" SHEET
1	21	DOOR COVER PANEL	EA21489-21			
1	20	FLIGHT MANUAL SUPPLEMENT 2148, 2149-1	EA21489-20			
1	20	FLIGHT MANUAL SUPPLEMENT 215, 412	EA21289-20			
1	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20469-20			
1	20	FLIGHT MANUAL SUPPLEMENT 2048	EA20469-20			
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19			
1	18	DOOR INNER SKIN	EA20469-18			
1	17	ANGLE	EA20469-17			
1	16	ARM REST ASSEMBLY	EA20469-16			
1	15	INSTRUMENT PANEL	EA20469-15			
1	14	WINDOW RETAINER	EA20469-14			
1	13	INSTRUMENT WINDOW	EA20469-13			
1	12	FORWARD RIS	EA20469-12			
1	11	ANGLE	EA20469-11			
1	10	REARWARD RIS	EA20469-10			
1	9	ANGLE	EA20469-09			
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08			
1	7	ANGLE	EA20469-07			
1	6	ALUMINUM STRIP	EA20469-06			
1	5	RUBBER STRIP	EA20469-05			
1	4	DOOR LATCH ASSEMBLY	EA20469-04			
1	3	PLEXIGLASS RUBBER WINDOW	EA20469-03			
2	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
1	1	INSTALLATION - BUBBLE WINDOW				

BASIC CODE

DASH NO. FOR DIA
IN-FTD HEAD NEAR SIDE
F-FTD HEAD FAR SIDE

DASH NO. FOR LENGTH

DIMENSIONS
TO BE DIM'ED
C=CONV ROUNDOFF

BASIC CODES:
BJ = MS2047040
BB = MS2042640
LZ = NAS107740
CX = MS2047000

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS

DATE

DESIGNED

CHECKED

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DIMENSIONS ANGLES
X.DIM ±0.010 ±1/2"
X.DIM ±0.003 ±1/2"
X.DIM ±0.1

AERO DESIGN LTD.

CONSTRUCTIVE ENGINEERING, TRANSPORT CANADA APPROVAL, 6000 HWY 100
1000 INDUSTRIAL ROAD #2, CALGARY, AB, T2C 1Y9

EAGLE COPTERS LTD.

825 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9

BELL 204, 205, 212 & 214
VERTICAL REFERENCE DOOR
INSTALLATION

SCALE AS NOTED

SHEET 3 OF 3

REV. 1

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